Date: Monday, 11/21/2005 11:53:27 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE, INBOARD, RS, 206
Job Number	: 23923		
Estimate Number	: 10821		
P.O. Number	: N/A	**Part Number**	: D26662
This Issue	: 11/21/2005 **S.O. No.** : N/A	**Drawing Number**	: D2666 REV. B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: B
Previous Run	: N/A	**Material**	: N/A 16
Written By	: SEE COMMENT BELOW	**Due Date**	: 12/20/2005 **Qty:** (12) **Um:** Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length
Batch No: B24896 En 06/01/05

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number. En 06/01/09
1-Inspect part number and batch number are programmed correctly. MB 06/01/09
2-Fixturing W/O No. N/A
3-Fixturing Inspection last completed on 06/01/09 by En
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet EG 06/01/14
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr EG IBL 06.01.11 16 (17)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet En 06/01/14 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE En 06/01/14 16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 06/01/19

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 11:53:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE, INBOARD, RS, 206

Job Number: 23923 **Part Number:** D26662

Job Number:

Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		J. G. 06/01/14
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		SAD 06/01/14
7.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		FC 06 01 17
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
	Comment: INSPECT POWDER COAT		06 01 17
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 364		CL 06/01/18 (16)
10.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL Inspection Level 21		SUE 06/01/19 (16) 06/01/19

Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	~~28~~ 23923
Description: 206 Saddle, Inboard, Right side	**Part Number:**	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		0.125	0.124	.121	.122		
B	0.100	0.140		0.120	0.130	.120	.121		
C	0.100	0.140		0.123	0.123	.120	.120		
D	0.210	0.230		0.220	0.220	.122	.122		
E	1.245	1.255		1.247	1.248	1.250	1.250		
F	1.245	1.255		1.247	1.248	1.250	1.250		
G	5.990	6.010		6.003	6.002	6.001	6.000		
H	0.510	0.515		0.517	0.512	0.517	0.512		
I	1.674	1.684		1.678	1.678	1.678	1.678		
J	2.495	2.505		2.500	2.497	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.116	0.117	.120	.122		
O	0.540	0.560		0.545	0.544	.545	.545		
P	0.490	0.510		0.497	0.497	.501	.500		
Q	3.609	3.619		3.610	3.612	3.612	3.611		
R	2.470	2.510		2.496	2.497	2.490	2.490		
S	0.240	0.270		0.252	0.253	.251	.252		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.130	1.131	1.131	1.131		
W	1.565	1.585	DT8695 A/B	—	—	—	—		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CP / BG
Date:	06.01.10

Audited by	J.G
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	23923
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		.120	.121	.121	.121		
B	0.100	0.140		~~.121~~	.122	.121	.122		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.003	6.004	6.004	6.004		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.240	0.238	0.238	0.238		
N	0.100	0.140		.120	.120	.121	.120		
O	0.540	0.560		.547	.546	.549	.550		
P	0.490	0.510		.498	.498	.498	.498		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.130	1.130	1.130	1.130		
W	1.565	1.585		—	—	—	—		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BG / EN
Date:	06.01.11 / 06/01/14

Audited by	J.G
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order:	23923
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	~~.121~~	.121	.120	.121	.120		
B	0.100	0.140	~~.122~~	.122	.122	.120	.122		
C	0.100	0.140	~~.120~~	.120	.120	.121	.120		
D	0.210	0.230	~~.220~~	.220	.220	.220	.220		
E	1.245	1.255	~~1.250~~	1.250	1.250	1.250	1.250		
F	1.245	1.255	~~1.250~~	1.250	1.250	1.250	1.250		
G	5.990	6.010	~~6.004~~	6.004	6.004	6.004	6.004		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684	~~1.679~~	1.679	1.679	1.679	1.679		
J	2.495	2.505	~~2.500~~	2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.498	.498	.498	.498		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.130	1.130	1.130	1.130		
W	1.565	1.585	DT8695 A/B	—	—	—	—		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BG / EP
Date:	06.01.11 / 06/01/14

Audited by	J.G.
Date:	06/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF RF	

RELEASED 03.06.18 RF

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.121		
B	0.100	0.140		.122	.122	.121	.121		
C	0.100	0.140		.123	.122	.122	.121		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.004	6.004	6.004	6.004		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.259	.259	.259	.259		
L	0.312	0.317	DT8686	.312	.312	.312	.312		
M	0.235	0.240		0.239	0.239	0.238	0.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.499	.498	.499	.499		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.851	.251	.251	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	0.313	0.318	DT8686	.318	.318	.318	.318		
V	1.125	1.145		1.130	1.130	1.130	1.130		
W	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RG / EN
Date:	06.01.11 / 06/01/14

Audited by	J.G
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF RF	

RELEASED 03.06.18 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:44 am

Work Order No	: 0023923		
Project Name	: D2666-2	Department Code:	
Project For	: WK535	Burden Flags	: NNNNNNN
Work Order Type	: Main	WO Status	: Open
Main WO Number	:	Invoice State	: Not Invoiced
House Part Number	: D2666-2	Invoice Date	:
Description	: Saddle, RH, Fwd,Aft, In	Invoice Number	:
Manufactured	: Yes	Invoice Amount	: 0.00
Amount Req'd	: 12		
Amount Done	: 0	Order Entry No	:
Start Date	: 08-02-05	OE Value	: 0.00
Est Finish Date	: 08-31-05		
Act Finish Date	:	Est Margin	: 0.000%
Drawings Reqd	: No	Actual Margin	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

535

DART AEROSPACE LTD.	Work Order :	23923
Description: 206 Saddle, Inboard, Right Side	Part Number:	D2666-2
Drawing: D2666 Rev. B	Qty:	(12) 16

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Dwg. not required RF 02/09/16	AP	05/03/04	12
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (D6101-001) RF 02/09/16 Batch No: B24890	EP	06/01/09	12
3	HAAS	Program part number and batch number.	EP	06/01/09	12
4	QC	Inspect part number and batch number are programmed correctly.	MS	06/01/09	12
5	HAAS	Fixturing W/O No. N/A Fixturing Inspection last completed 06/01/09 by EP	EP	06/01/09	12
6	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	EP	06/01/14	12
7	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	EP	06/01/14	12
8	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	EP	06/01/14	12
9	LAGUN	Machine Keyway and inspect per attached dimension sheet	EP	06/01/14	12
10	METAL	Deburr	EP	06/01/14	12
11	QC	Inspect Level 1	EP	06/01/14	12
12	QC	Inspect Level 8	J.G	06/01/14	12
13	METAL	Acid etch and Alodine as per QSI 005 4.1	SAD	06/01/14	12
14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	FC	06/01/17	12
15	QC	Inspect Level 3	MM	06/01/17	12
16	STORES	Pack in foam, identify and stock.			
17	EXPEDITING	Close Work Order Job Cost / Part			

Rev	Date	Change	Created By	Approved
A	97.07.24	New Issue		
B	98.09.08	Inspection levels, added powder coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED
DEC 1 8 2000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ **Date:** _____

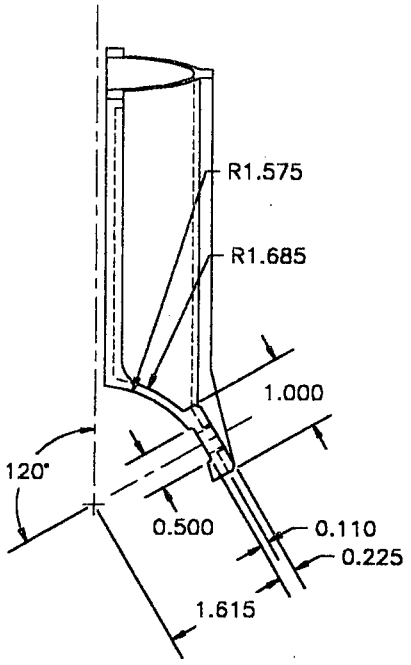
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO. D2666	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD INSIDE HIGH	SCALE 2:5

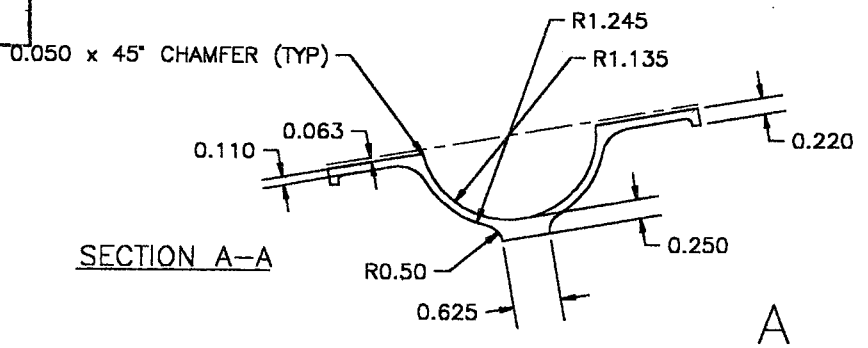
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED

EFFECTIVE	DEOs
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	

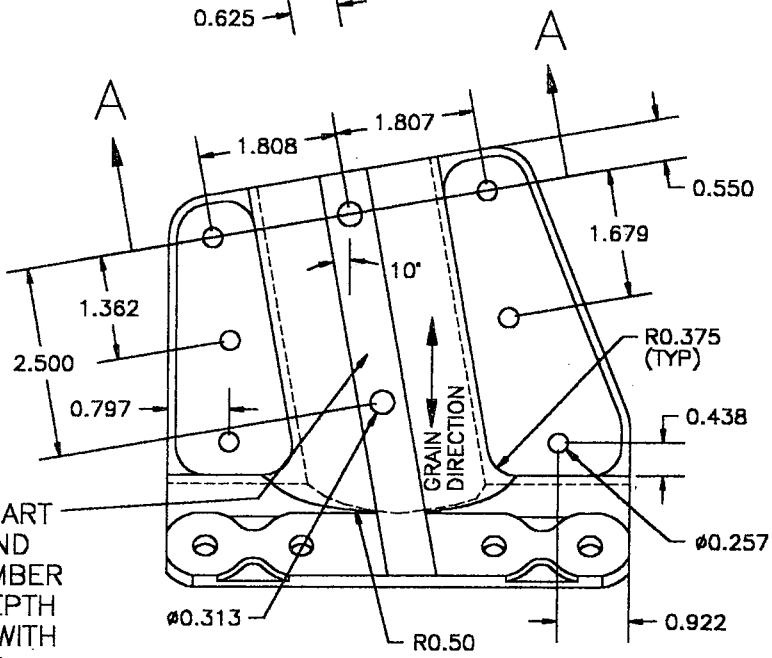
SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 23923

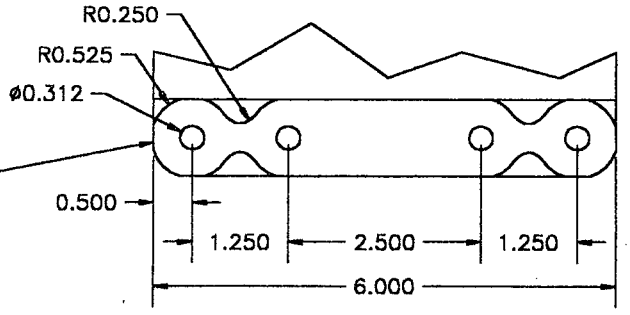




SECTION A–A



ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



RELEASED
97/07/16 DS
ECN 008

CP00.0505

MATERIAL: ~~7075 T651 OR~~ 7075–T7351 (QQ–A–250/12)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2
NOTE: D2666–1 SHOWN (D2666–2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No : 0023923
Project Name : D2666-2
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : D2666-2
Description : Saddle, RH, Fwd,Aft, In
Manufactured : Yes
Amount Req'd : 12
Amount Done : 0
Start Date : 08-02-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00